which case the finished bosses, of course, must stand in a certain relation to the locating point; such bosses are indicated at *E,* from which measurements *B* can be taken to surfaces *G* on the work. The three lugs // are provided for clamping purposes, the jig being clamped in three places only to avoid unnecessary springing action. If the jig is in constant; use, it would be advisable to have special clamping arrangements as component parts of the jig for clamping it to the table, thereby avoiding loss of time in finding suitable clamps.

The walls or standards *K* of large jigs of this type are frequently made in loose pieces and secured and doweled in place. In such a case, the most important thing is to fasten these

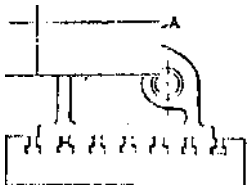

Fig. 2. Simple Design **of Adjustable** Boring Jig

members firmly to the base, prevent ing shifting by tongues, keys, or dowels. It is evident that, when the standards are made loose, it is easier to finish the pad of the base, and this is of importance, particularly when difficult locating arrangements are planed or milled in the base; tin*

patternmaker's and the molder's work is also simplified As a rule* the standards are screwed to the base permanently and then the bushing holes are bored. In some cases, however, ft may hi* easier to first bore the hole in a loose part, ancl then attach it to the main body.

Adjustable Boring Jigs* — When boring jigs are designed for machine parts of a similar design hut of different dimensions, arrangements are often made to make one jig take various sizes. In such a case, one or both standards may have* to be moved, and extra pads are provided on the face. This shifting